

Work Order ID 71041

Tuesday, June 21, 2011 1:14:12 PM

Page 1

Item ID: D3413-1

Accept

Revision ID:

Item Name: Ring

Setup Start

Stop

Start Date: 6/21/2011 Start Qty: 6.00

Required Date: 7/8/2011 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3413

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3413

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

304 .250x 4"

IB11-6-30

(6)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB11-6-30

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/07/04

(76)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1 .

6/21/07/04 (6)

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8/6/07/04

(6)

145

0.00



SprayPaint

Memo

0.00

Spray Painting

PRIME B 117319
DELFLEET BLUE B 115985
DELFLEET CLEAR B 117113

m 11 07 13 (6)

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Setup Start

Revision ID:

Stop

Item Name: Ring



Start Date: 6/21/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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155

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

BT 11-07-14 (x6)

170

Identify as per dwg & Stock Location: 420

0.00



Packaging

Memo

0.00

Packaging

11/7/15

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/15
MF 11-07-15

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Picklist Print

Tuesday, June 21, 2011 1:14:18 PM

Page 1

Work Order ID: 71041

Parent Item: D3413-1

Parent Item Name: Ring



Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 05.09.13 New issue KJ/JLM
IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000		Purchased	No			100	f	8.2000	0.25	1.578947			
304 BAR .250 x 4.00													

B11-6-30

Location

Loc Qty

Loc Code

MAT050

8.2

116808

8.2

116808

6

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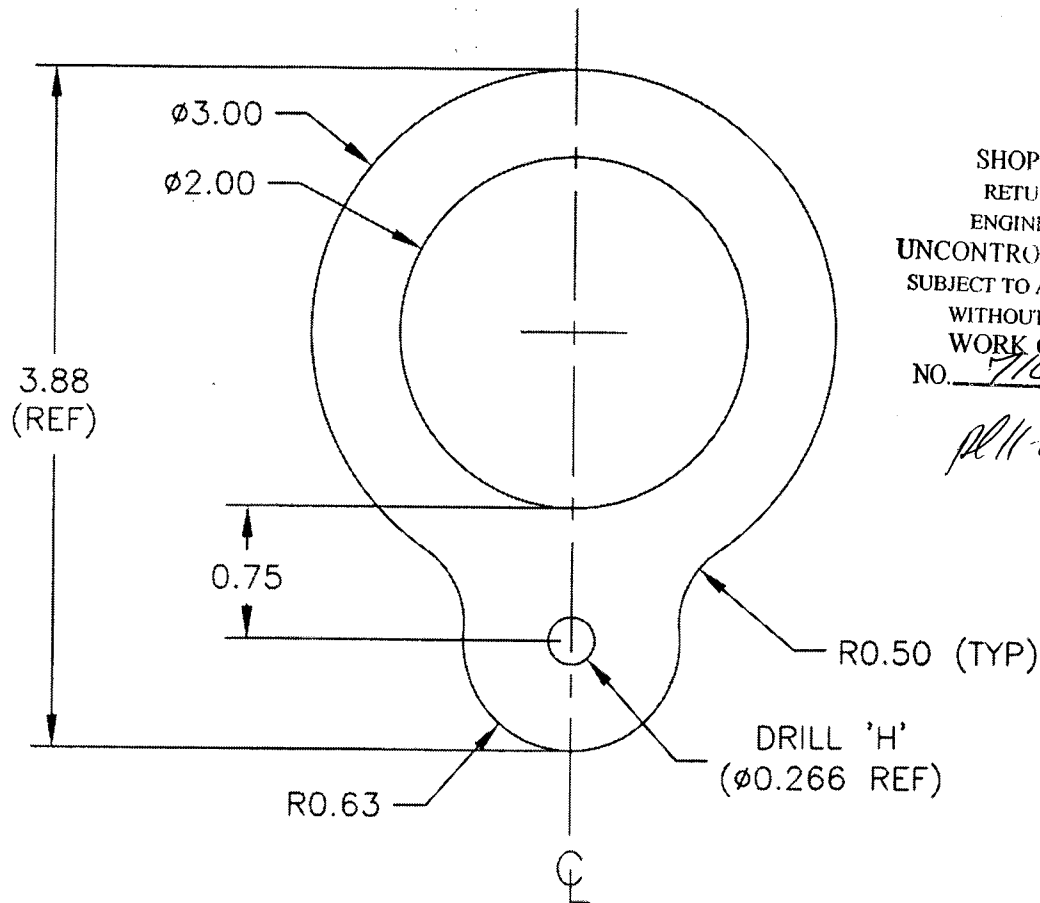
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71041

PL 11-06-21

D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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